

# Work Order ID 70942

Monday, June 20, 2011 8:50:17 AM

Page 1

Item ID: D2651-1

Accept

Setup Start

Revision ID:

Stop

Item Name: Plug

Start Date: 6/20/2011 Start Qty: 80.00

Cust Item ID:

Required Date: 7/4/2011 Req'd Qty: 80.00

Customer:

Reference:

Approvals:

Process Plan:

Date: 11/06/20

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D2651

Rev B

100

0.00



Hardinge CNC LATHE SMALL

Hardinge

Memo

0.00

Hardinge CNC Lathe Small

1- Turn as per Folio FA219 and Dwg D2651 2- Deburr

110

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

120

0.00



QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

Blue  
SHIP  
JULY 8th

80

80

10/6/20

11/6/20

11/06/20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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*BlOE*



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Revision ID:					Stop	
Item Name:	Plug					
Start Date:	6/20/2011	Start Qty:	80.00			
Required Date:	7/4/2011	Req'd Qty:	80.00			
Reference:						

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 	Small Fab	0.00				80			
Small Fab	Memo	0.00	<i>2</i>	<i>11/6/20</i>					
Small Fab	Deburr ias per dwg D2651								
140 	Chemical Conversion Coat per QSI005 4.1	0.00				80			
HandFinish	Memo	0.00							
Hand Finishing									
155 	SprayPaint	0.00				<i>m</i>	<i>11</i>	<i>06</i>	<i>28</i>
Spray Painting	Memo	0.00							<i>(80)</i>
	PRIME B <i>117319</i>								
	DELFLEET BLUE B <i>115985</i>								
	DELFLEET CLEAR B <i>117113</i>								

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**Work Order ID 70942**

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Item ID: D2651-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Plug

Start Date: 6/20/2011 Start Qty: 80.00



Cust Item ID:

Required Date: 7/4/2011 Req'd Qty: 80.00



Customer:

Reference:

Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

165

QC14- Inspect Spray Paint

0.00



QC

Memo

0.00

Quality Control

2T 11-06-29 (x80)

170

Identify as per dwg & Stock Location: FP-A

0.00



Packaging

Memo

0.00

Packaging

x80 d 11/06/29

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/06/29

11-06-29

(80)

W/O:		WORK ORDER CHANGES					
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**NOTE:** Date & initial all entries

# Picklist Print

Monday, June 20, 2011 8:50:24 AM

Page 1

Work Order ID: 70942



Parent Item: D2651-1



Parent Item Name: Plug

Start Date: 6/20/2011

Required Date: 7/4/2011

Start Qty: 80.00

Required Qty: 80.00

Comments: IPP: A 02.04.15 New Issue NG  
IPP: B 05.12.12 added deburr EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M6061T6R0.500

Purchased

No

100

f

83.6050

0.0401

3.376842



1156/20

6061-T6 Round Bar .500"

Location

Loc Qty

Loc Code

MAT012

83.605

114488

4.605

117379

79

3.3-81

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Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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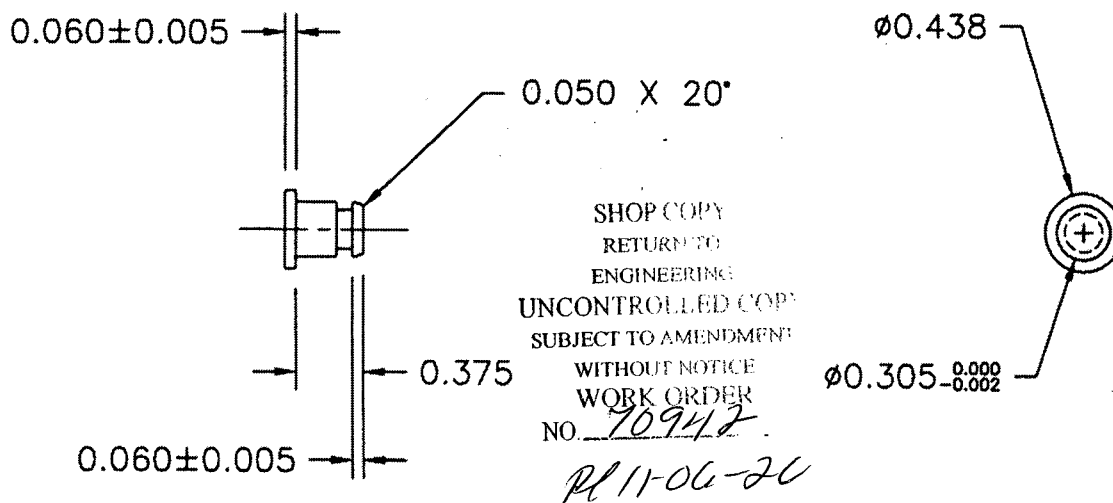
**NOTE:** Date & initial all entries



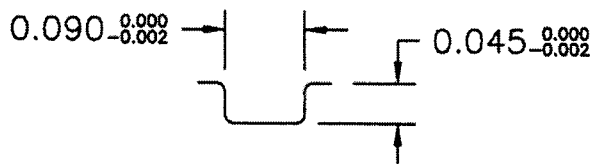
DESIGN #	DRAWN BY #	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D2651	REV. B SHEET 1 OF 1
DATE 03.12.19		TITLE PLUG	SCALE 1:1
A	97.03.25	NEW ISSUE	
B	03.12.19	ADD POWDER COAT, MS28775-008	

RELEASED  
03.12.19 #

### D2651-1 PLUG:



### GROOVE DETAIL (SCALE 5:1)



### D2651-1 PLUG

- 1) MATERIAL: 6061-T6 (QQ-A-225/8) OR 1100-0 (QQ-A-225/1)
- 2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1  
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.010 MAX

### D2651-3 O-RING

- 1) MATERIAL: BUNA N, 70 DUROMETER  
3/16 ID, 5/16 OD, 1/16 WIDTH  
(PARKER 2-008, MS28775-008 OR EQUIVALENT)

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